

Date: Friday, 01/08/2008 10:42:32 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUSSET		
Job Number	: 40893C		Part Number	: D22495		
Estimate Number	: 10843		Drawing Number	: D2249 REV. E		
P.O. Number	:		Project Number	: N/A		
This Issue	01/08/2008	S.O. No. :	Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	1 /	Type : SMALL /MED FAB	Due Date	10/08/2008	Qty:	20
Previous Run	: 40486C		Um:	Each		
Written By	:					
Checked & Approved By	: <u>JUL 08.8.05</u>					
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.0243 sf(s)/Unit Total : 0.4860 sf(s) 304/316 .063 Sheet Material: AISI 304/316 SS 0.063" thick (M304S16GA) Batch: <u>M108724</u>		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 1.000" x 1.600"		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr any rough edges		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:32 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 40893C

Part Number: D22495

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/17 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



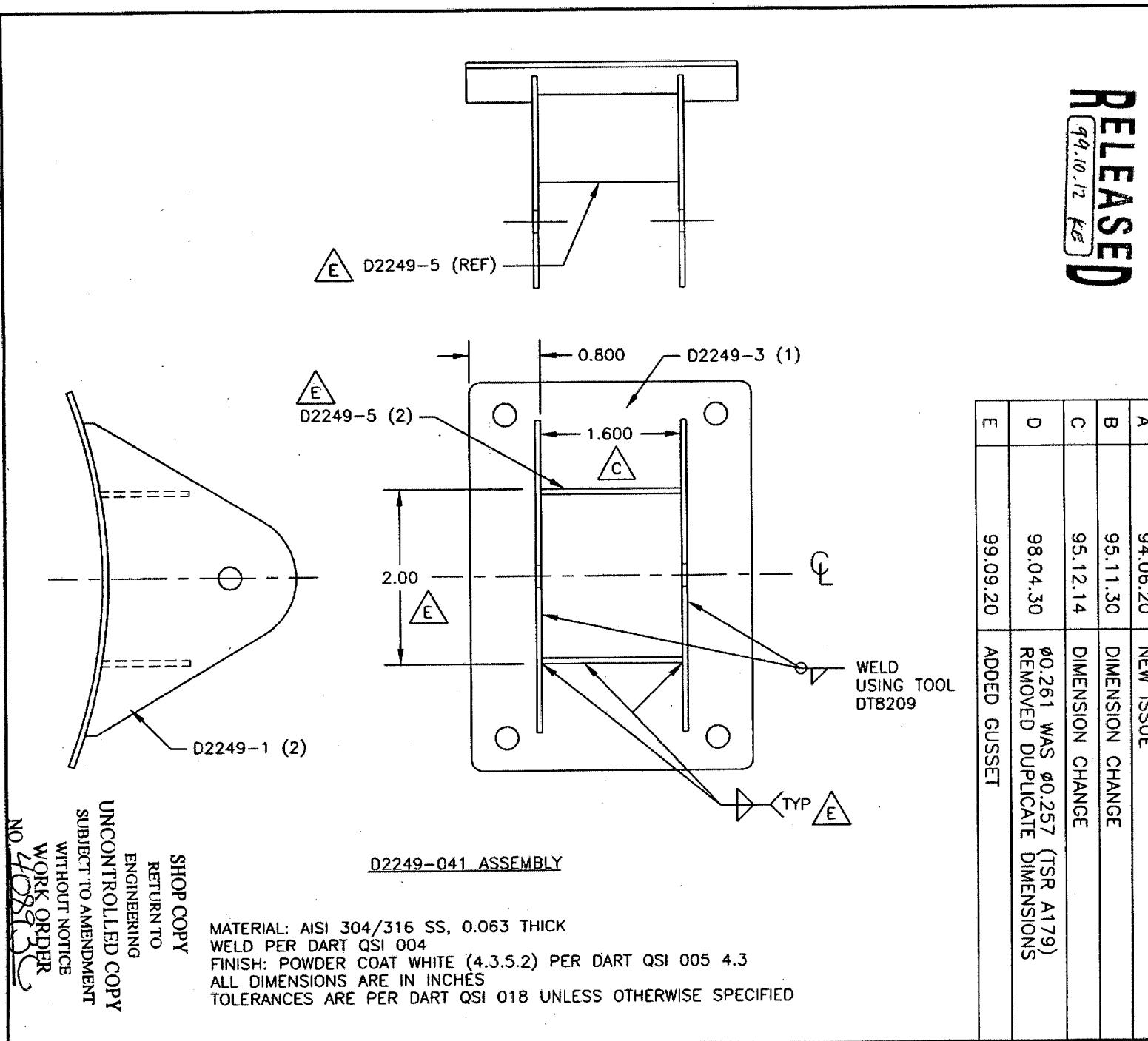
JF 08-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRAWN BY		DART AEROSPACE LTD	
RF		HAWKESBURY, ONTARIO, CANADA	
APPROVED		REV. E	
T		SHEET 1 OF 4	
DRAWING NO.		D2249	
CHECKED		RE	
DESIGN			

RELEASER
99.10.12
KCE

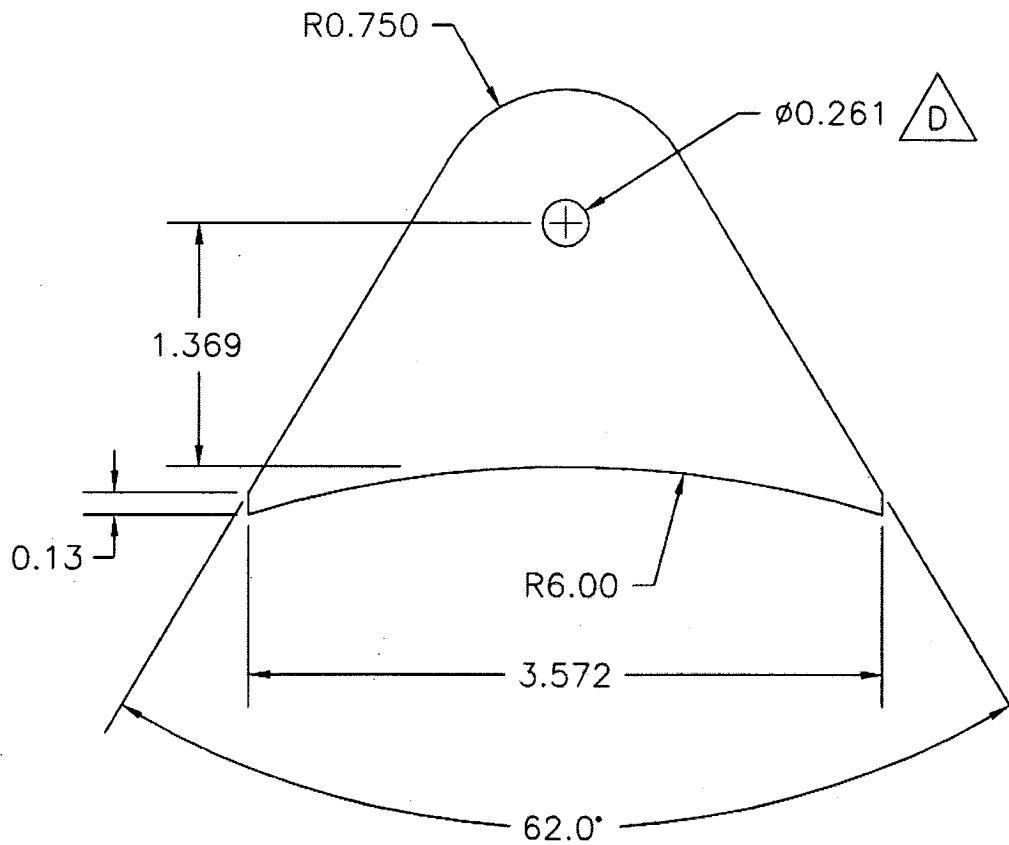
99.10.12 KES

5.1.5.
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 40893C

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40893

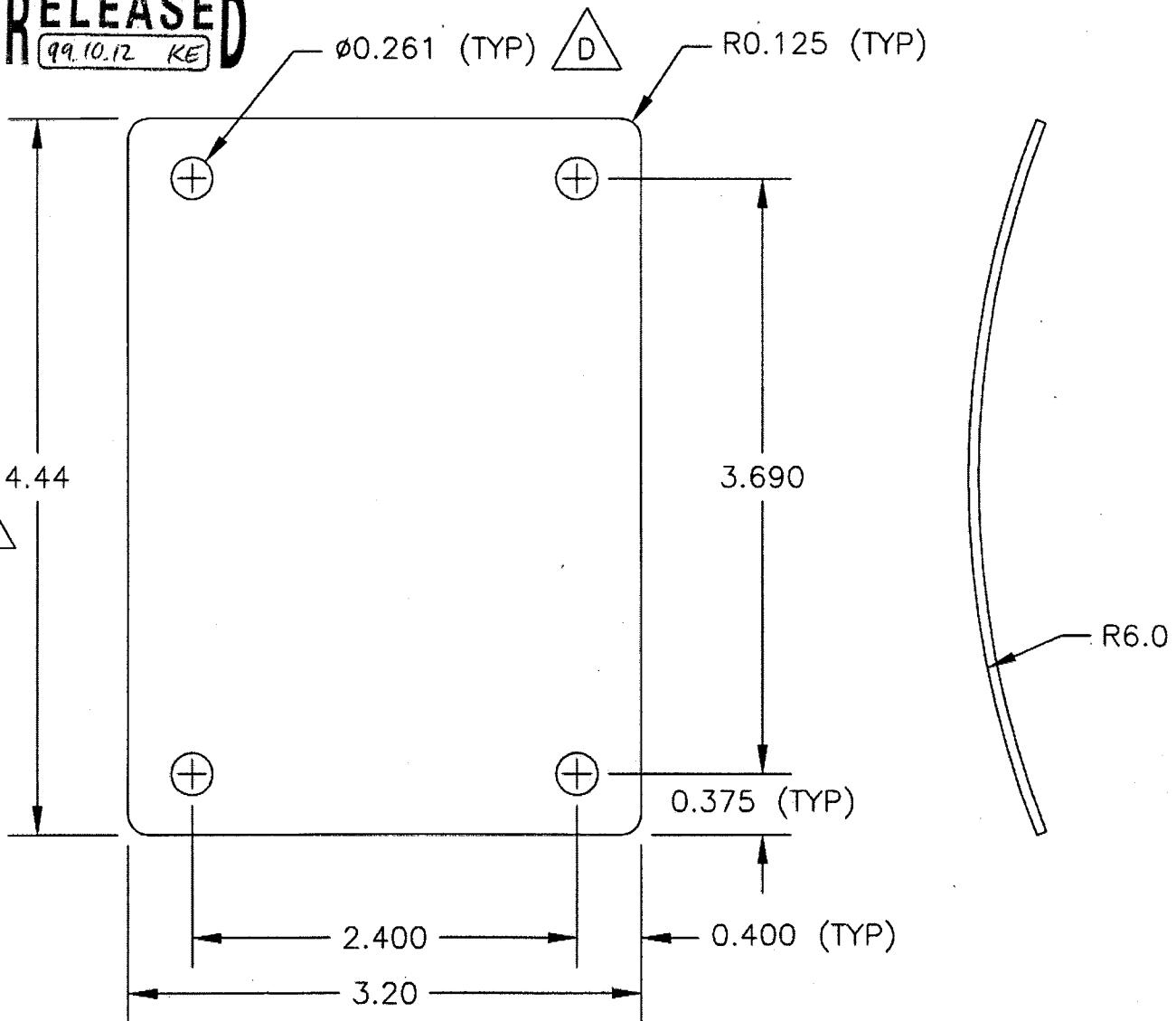
MATERIAL: AISI 304/316 SS. 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>RE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>TH</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KE

99.10.12 KE



FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. WORK ORDER 10093.

SHOP COPY

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SUBJECT TO AMENDMENT

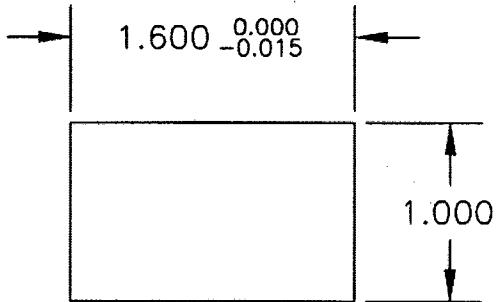
**WITHOUT NOTICE
WAS BY ORDER**

WORK ORDER
1093

NO. 40873

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
19.10.12 KED2249-5 GUSSET

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 408936

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED